Work Orde September-23-1				*107	7.302*							Page 1
Item ID: Revision ID: Item Name:	D3912-5 Eyebolt Plate			Accept	*N900	<u>040</u>	100) *	Setup	Start Stop	1 🚺	S1* S2*
Start Date: Required Date: Reference:	10/07/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item Customer:						IVI	. 7
Approvals:		nn: <u>μ</u> υΣ	Date: 13-09-2			ate:			Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr										
-D3912	В											
100				0.00								
100 Waterjet FLOW CNC Water	••	Memo Cut as per o Prog Rev:_ Dwg Rev:_		0.00				_6		>		JM13-11-5
309 1143	3	Dwg Rev:_ Deburr as r										1/3
110		QC2- Inspect parts off r	nachine FAI/FAIB	0.00				4				
*11 0 *		Memo		0.00				6				Jm13-11-5

Quality Control

											DQA:	Date:	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	O	NFORI	MANCE / UP	DATE	QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DE			
Part N	- ۱۰۰					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	i	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	[•	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data						••							
Equip/Tooling													
Operator													
Material													
Setup							l						
Other													
Process													
Supplier													
Training			İ										
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng G	ear				General					_		
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	t 「	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Ord September-23-1					*107	30	2*						Page
Item ID: Revision ID: Item Name:	D3912-5 Eyebolt Plate			Accept		*\	1900	040	100) *	Setup Sta	IVI	S1* S2*
Start Date: Required Date Reference:	10/07/13 : 10/07/13	Start Qty: 6.00 Req'd Qty: 6.00		'6* '6*			Cust Item I Customer:	D:					
Approvals:	Process Pla	an:	Date:	Toolin	ıg:		Da	ite:		F	Run Sta	I <i>/</i> J	R1*
-					Y/N):		Da	ite:			Sto	*N	R2*
Sequence ID/ Work Center 1	D	Operation Description			Up/ n Hզ<u>ր</u>բՏ		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		QC8- Inspect parts - seco	and check	0.00	27 9-89					ŕ			
120 QC Quality Control		Memo		0.00	13.11.	5				6			
130		Identify as per dwg & St	ock Location:_	ST 199 0.00						į			DAS 26
130 Packaging		Memo		0.00						QX_			9-89

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

Packaging

*14**0***

Quality Control

140

13-11-6. MRE 13-11-06

Page 2

DAS

												DQA:	Da	te:	
NCR:	es/	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	0.	- A Closed:	 Da	to.	
						DISPOSITION	-			AGAINST D				<u></u>	
Work Orde	er:					DISFOSITION		İ		AGAINSI D			TROCESS		
						Rework			Skid-tube	Crosstube	╛		Water Jet		Engineering
Part N	۱٥٠					Scrap			Machining	Small Fab	╛	Prod	d. Eng. Coor.	\bigsqcup	Quality
						Use-as-is]	Thern	noforming	Finishing	╛	Rec/Stor	e/Packaging		Other
NCR 1	No.					Work Order Update]		Large Fab	Composite	╛		Supplier		
			,	,											
Root					}	ption of work order update	1	Initial		tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	\bot	Date	Verificatio	n	QC Inspector
Doc/Data							ļ					Ì			
Equip/Tooling							Ì								
Operator															
Material							1								
Setup														-	
Other															
Process															
Supplier														İ	
Training															
Unapproved					İ										
						F	AUI	T CATE	GORY						
Landi	ng (Gear				General									-
		Bending				Bend		Grain			Jo.	valized			Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire	Γ	0	ver/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspect	ion Incomplete	Γ	Pa	art Incorrec	:t		Weld
		Crushed/	Crimped			Burrs		Instruct	tions Incomplete/	'Unclear	Pa	art Lost/Mi	ssing		Wrong Stock Pulled

Maintenance

Out of Calibration
Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Picklist Print

September-23-13 11:47:31 AM

Work Order ID:

107302

Parent Item:

D3912-5

Parent Item Name:

Eyebolt Plate

Start Date: 10/07/13

Required Date: 10/07/13

Start Qty: 6.00

Required Qty: 6.00

Comments.

IPP RevA: new issue DD 09.11.17 verified by:EC

Comments:	IPP RevA: new iss	sue DD 09.11.17	verified t	by:EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	235.0833	0.05125	<i>-0.3236</i> 844 ⊘-S	,	Jm	13-11-5
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT020		235.0832632							
				122	521	19.1432632							
				124	445	46.52							
				M12	26075	169 42			126	ヘコく			

Page 1

											DQA:	Date	:
NCR:	⁄es	/ No				WORK ORDER NON-O	CONFO)RN	MANCE / UPDATE		QA Closed:	Date	:
Work Orde	or:					DISPOSITION			AGAINS"	r de	PARTMENT,	/PROCESS	
Part NCR I	- . No.					Rework Scrap Use-as-is Work Order Update] 	nerm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Initia	al	Action		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief	Eng	Description		Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling											Ì		
Operator													
Material							1						
Setup					1								
Other			<u> </u>		Ì								
Process											;		
Supplier	П												
Training	П								•				
Unapproved													
						F	AULT C	ATE	GORY				
Landi	ng G	Gear				General					_		
		Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	Har	rdwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	Ins	pecti	on Incomplete		Part Incorre	ct [Weld
		Crushed/	Crimped			Burrs	Ins	truct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	Ma	ainte	nance		Part Moved	_	
		Heat Trea	it			Countersink	Mis	slabe	led		Positioned V	Vrong	
	П	Inspectio	n Strin in	Tube		Cut Too Short	Пмі	sread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	107302
Description: Eyebolt Plate	Part Number:	D3912-5
Inspection Dwg: D3912 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

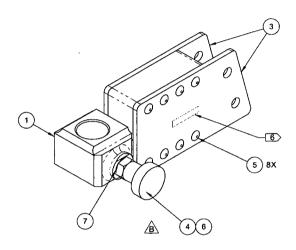
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.129	-		V	JAmoi
Ø0.257	+0.006-0.001	6755	-		V	
0.38	+/-0.030	0.384	-		V	
1.500	+/-0.010	1,503	-		V	
0.500 Pitch	+/-0.010	o√209,	_		٧	
3.15	+/-0.030	3.15	_		V	
0.375	+/-0.010	0.379	_		V	
0.517	+/-0.010	<i>⊙</i> .≤∂ <i>₀</i> °	-		V	
1.000	+/-0.010	1.002"	_		V	
3.65	+/-0.030	3.651	-		ν	
1.500	+0.020/-0.000	1.503"	-		٧	
0.25	+/-0.030	0.522,,	~		V	
2.00	+/-0.030	2.000	_		U	
0.125	+/-0.010	0.116			7	
						
•						
			 			
			DAS			

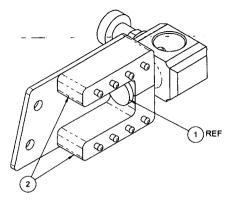
Measured by: Jm	Audited by:	27 9-89	Preliminary Approval:	
Date: 13-11-5	Date:	13-11-5	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.06.07	New Issue	KJ 10	1 1
В	10.08.09	Dwg Rev updated	KJ OK	144
			171	

ITEM	QTY -041	P/N	DESCRIPTION	
	Х	D3912-041	EYEBOLT RECEIVER ASSY	
1	1	D3912-1	EYEBOLT	\dashv
2	2	D3912-3	EYEBOLT BLOCK	
3	2	D3912-5	EYEBOLT PLATE	
4	1	D3801-1	SPRING PLUNGER	
5	8.	MS20615-4M20	RIVET -	
6	1	MS21209-F615	HELICAL	
7	1	NAS1149F0332P	WASHER	







2

SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

10730ZML5 13-09-25



D3912-041 EYEBOLT RECEIVER ASSY

С

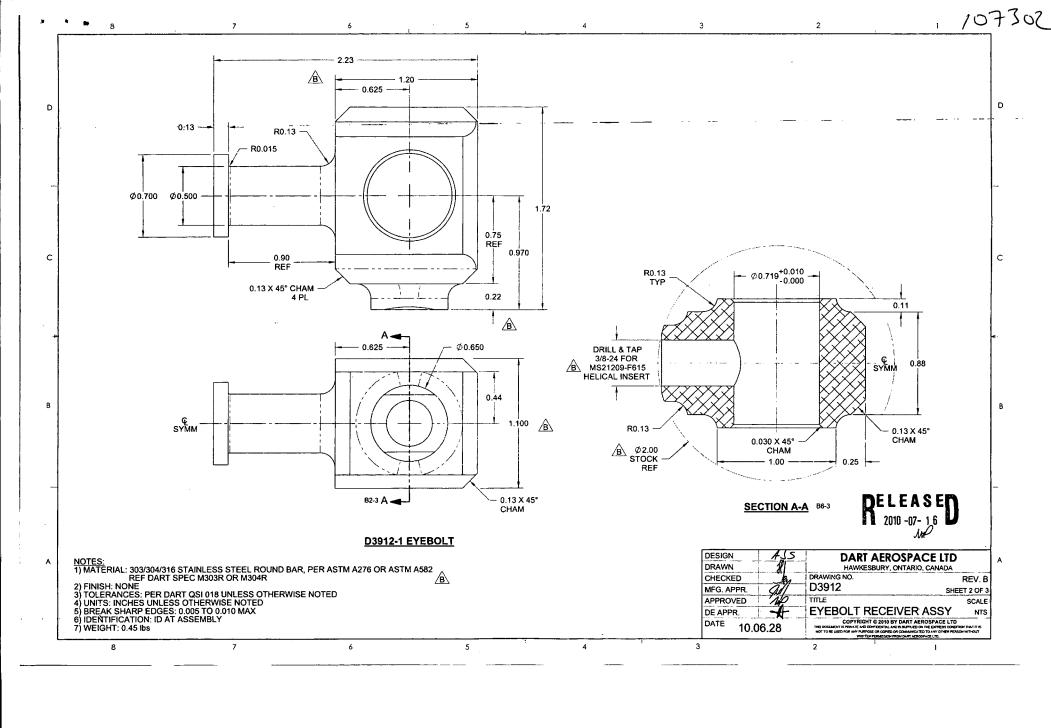
NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -041: 1.58 lbs

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; M521209-F615 WAS M521209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. JPH 10.06.28 NEW ISSUE 10.03.04 JPH Α REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED SCALE

EYEBOLT RECEIVER ASSY DE APPR. DATE

10.06.28

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIA, AND IS SUPPLED ON THE EXPRESS CONDITION ON TO BE USED FOR ANY INVESTIGATION OF COMPANIANCE TO TO ANY OTHER PERSON



107302

0.800+0.000 2.30 Ø0.129 THRU 1.500 4 PL -- 0.400 |- 0.500 PITCH 0.50 REF 1.00 $0.750^{+0.000}_{-0.020}$ R0.13 0.500 R0.125 TYP 0.516 +0.015 0.63

D3912-3 EYEBOLT BLOCK

- 3.15 1.500 0.500 PITCH ∫0.375ر R0.13 TYP 0.25 0.517 1.000 1.500+0.020 2.00 REF Φ-Ø0.129 Ø0.257 8 PL 0.125 2 PL REF 3.65 3.69 REF

D3912-5 EYEBOLT PLATE

DESIGN	4.(5	DART AEROSPACE LTD	
DRAWN	1/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	-Ba	DRAWING NO.	REV. B
MFG. APPR.	all	□ D3912 _{SHI}	ET 3 OF 3
APPROVED	119	TITLE	SCALE
DE APPR.		EYEBOLT RECEIVER ASSY	NTS
DATE 10.0	6.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDE WHO COMPENSTAL AND IS SUPPLED ON THE EXPRESS COM- NOT TO BE USED FOR NAM PLEYOSE OR COPPED OR COMMANDIATE TO ANY OTHER PER	FRON THAT IT IS

NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B

-5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA

D

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY
7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs